Work Order ID 64260

Page 1

Wednesday, December 01, 2010 9:08:27 AM

Item ID:

D4021-7

Accept

Date:

Setup Start

Revision ID:

Item Name: Hoop

Required Date: 12/8/2010

12/1/2010

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Process Plan:

QC:

Date:

Tooling:

0.00

0.00

SPC (Y/N):

Date:

Run Start

Stop

Stop

Sequence ID/ Work Center ID Operation Description

Revision Nbr

Set Up/ **Run Hours** **Tool ID**

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

Draw Nbr D4021

В

100

FLOW CNC Waterjet

Waterjet

Memo

Cut as per dwg D4021

Dwg Rev:

1810-12-2

110

Quality Control

QC

QC2- Inspect parts off machine FAI/FAIB

Deburr as required

0.00

0.00

B10-12-2

Memo

| W/O: | - | | WC | RK ORDER CHANG | GES | | · · · · · · · | | | | | |
|---------|------|--------------------------------|----------------------------------|--|---------|----------------|---------------|-----------------|-------------------------------|--------------------------|--|--|
| DATE | STEP | PRO | OCEDURE CHA | NGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | |
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| Part No |): | PAR #: | Fault Cate | gory: | NCI | R: Yes 1 | lo DQ | A: | Date: _ | | | |
| | R | esolution: | Dispositio | n: | QA | : N/C Clo | sed: | | Date: _ | | | |
| NCR: | | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | | |
| DATE | STEP | Description of NC Section A | Initial Chief Eng | Corrective Action Secondaries Action Description Chief Eng | ction B | Sign & Date | | cation ion C | Approval Chief Eng | Approval QC Inspector | | |
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Wednesday, December 01, 2010 9:08:27 AM

Item ID:

D4021-7

Item Name: Hoop

Start Date:

Revision ID:

12/1/2010

Start Otv: 6.00 Req'd Qty: 6.00

Required Date: 12/8/2010

OC:



Accept



Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date: _____

SPC (Y/N):

Date:

Date:

Run

Start Stop



Sequence ID/

Work Center ID

120

·OC

Ouality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/

Run Hours

Tool ID Tool#

Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

130

Small Fab

Small Fab

Memo

1- make radius as per dwg

2- deburr

0.00

140

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

| | - | | | | | | | | | |
|---------|------|----------------------------------|--|------------------------------|----------------|--------|--------|--------|-------------------------------------|--------------------------|
| W/O: | | | W | ORK ORDER CHANG | GES | · | | | | |
| DATE | STEP | PRO | OCEDURE CH | ANGE | E | у | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Cat | egory: | NCR: | Yes 1 | lo DQ | A: | _ Date: _ | |
| | Res | olution: | Dispositi | on: | QA: N | /C Clo | sed: | | Date: _ | |
| NCR: | | 1 | WORK OR | DER NON-CONFORM | IANCE (| NCR) |) - | | | |
| DATE | OTED | Description of NC | Corrective Action Section Initial Action Description | | | | Verifi | cation | Approval | Approval |
| DATE | SIEP | STEP Description of NC Section A | | Action Description Chief Eng | Sign & Date | | | tion C | Chief Eng | QC Inspector |
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Work Order ID 64260

Wednesday, December 01, 2010 9:08:27 AM



Page 3

Item ID:

D4021-7

Accept

Setup Start

Siop



Revision ID:

Item Name:

Hoop

Start Date: 12/1/2010

Start Qty: 6.00

Required Date: 12/8/2010

Req'd Qty: 6.00



Date:_____

Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Date:

Tool # Plan.

Code

Run

Reject

Qty

Start Stop

Reject

Number

Sequence ID/

Work Center ID

150

Packaging

Operation Description

Identify as per dwg & Stock Location: WA

Set Up/ **Run Hours**

SPC (Y/N):

0.00



Insp.

Stamp

Packaging

Memo

0.00

Accept

Qty

160

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

| Duit Mo | oopaoo | B-1-04 | | | | | | | |
|---------|--------|-------------------|----------------------|--|---------|-------------|-------------|-------------------------------------|--------------------------|
| W/O: | | | WO | RK ORDER CHANG | ES | | | | |
| DATE | STEP | PRO | OCEDURE CHAI | IGE | Ву | Da | te Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Cate | jory: | NCR: Ye | es No | DQA: | Date: _ | |
| | Re | esolution: | Disposition | 1: | QA: N/C | Closed | l: | Date: _ | |
| NCR: | | | WORK ORDI | ER NON-CONFORM | ANCE (N | CR) | | | |
| DATE | 0=== | Description of NC | I | | tion B | v | erification | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Initial Action Description Chief Eng Chief Eng | | ın & ate | Section C | Chief Eng | QC Inspector |
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Picklist Print

Wednesday, December 01, 2010 9:08:32 AM

Work Order ID: 64260

Parent Item: D4021-7

Parent Item Name: Hop



Star. Date: 12/1/2010

Requirec Date: 12/8/2010

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB

IPP Rev:B as

DD 10.04.20 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304B0.625X3.000 | | Purchased | No | | _ | 100 | f | 0.0000 | 0.4166 | 2.631158 | 3 | | |
| | | | | | | | | | | BIO- | 19-5 | | |

304 BAR .625 X 3.00



Page 1

| Dart Ae | rospace | e Ltd | | | | | | | t |
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| W/O: | | | W | ORK ORDER CHANGES | | | | | |
| DATE | STEP | PRO | CEDURE CHA | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| Part No | | | | egory:NC | | | | | |
| | R | esolution: | Disposition: QA: N/C Closed: Date: | | | | | | |
| NCR: | | | WORK ORD | ER NON-CONFORMANC | E (NCF | R) | | | |
| | 0750 | Description of NC | | Corrective Action Section B | | Verific | ation | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section Section | | Chief Eng | QC Inspector |
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| DART AEROSPACE LTD | Work Order: | 44240 |
|------------------------------|--------------|-------------|
| Description: Hoop | Part Number: | D4021-7 |
| Inspection Dwg: D4021 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

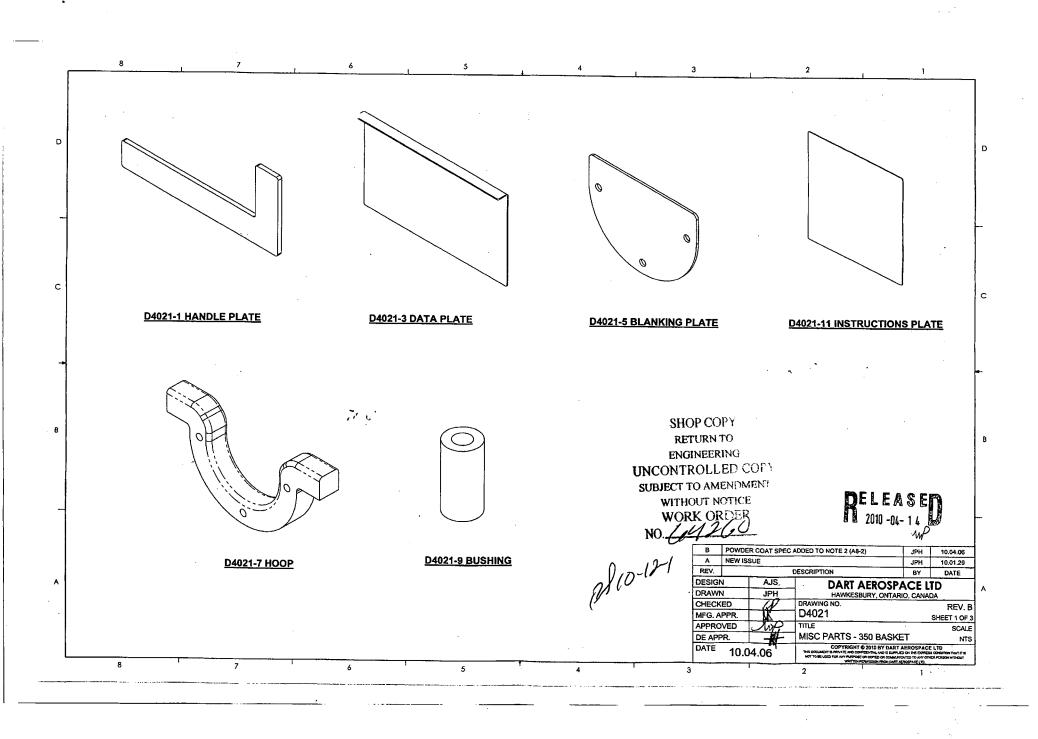
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
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| 5.00 | +/-0.030 | 4.990 | A | | V. | |
| 0.815 | +/-0.010 | 1813 | * | | V | |
| 2.500 | +/-0.010 | 2.500 | X | | V | |
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| Measured by: | B | Audited by: | 8 | Preliminary Approval: | N/A |
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| Date: | 10-12-2 | Date: | 10/12/00 | Date: | N/A |

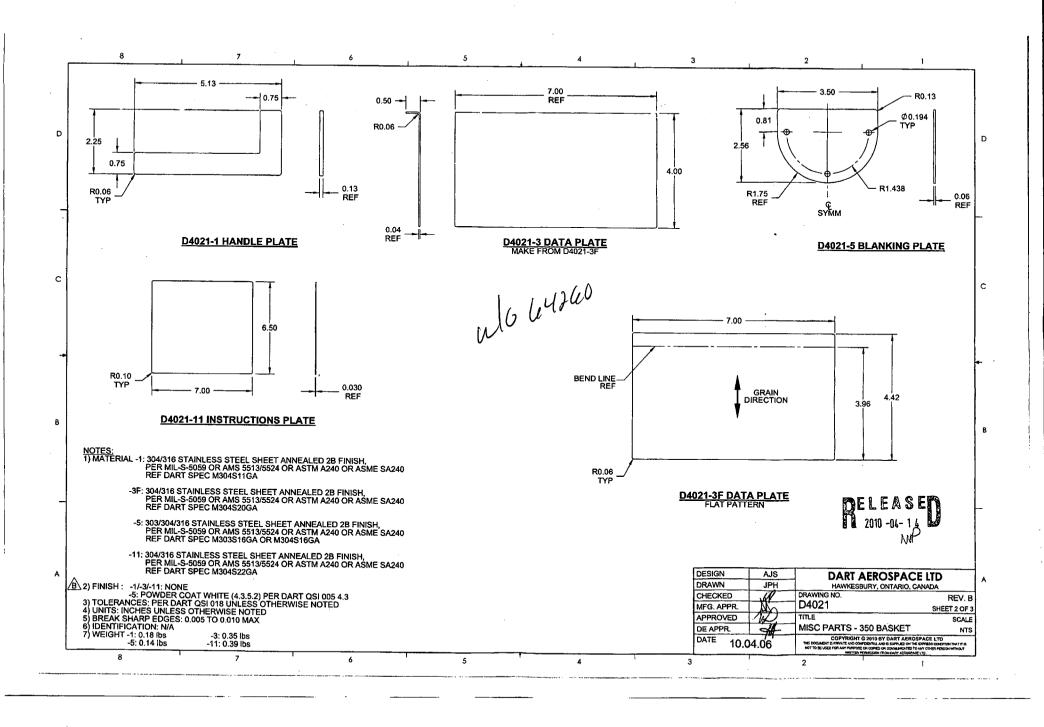
| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| Α | 10. 4.01 | New Issue | KJ | LI. |
| В | 10.08.18 | Dimensions revised per Dwg Rev_B | KJ K | |
| | | | 117 | |

| W/O: | | A., | WC | RK ORDER CHANG | ES | | | |
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| DATE | STEP | PRC | CEDURE CHA | NGE | Ву | Date Qt | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Cate | gory: | NCR: Yes | No DQA: | Date: _ | |
| | R | esolution: | Disposition | n: | _ QA: N/C Clo | sed: | Date: _ | |
| NCR: | | | WORK ORD | ER NON-CONFORMA | NCE (NCR |) | | |
| DATE | STED | Description of NC | | Corrective Action Section | | Verificatio | | Approval |
| DATE | SIEF | STEP Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | QC Inspector |
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| W/O: | | | WO | RK ORDER CHANG | ES | | | | |
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| NCR: | | | WORK ORDE | R NON-CONFORM | ANCE (NO | CR) | | | |
| DATE | | Description of NC | | | tion B | Vei | ification | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Initial Action Description Chief Eng Chief Eng | | | ection C | Chief Eng | QC Inspector |
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| W/O: | | | WO | RK ORDER CHANG | ES | | | | |
| DATE | STEP | PRO | CEDURE CHAI | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No |): | PAR #: | Fault Cate | gory: | NCR: Yes | No DQ | A: | Date: _ | |
| | R | esolution: | Disposition | 1: | _ QA: N/C C | losed: | | Date: _ | |
| NCR: | | \ | WORK ORD | ER NON-CONFORMA | NCE (NCI | ₹) | | | |
| DATE | STEP | Description of NC Section A | Corrective Action Initial Action Descr | | on B Sign Date | & Secti | cation on C | Approval Chief Eng | Approval QC Inspector |
| | | | Chief Eng | Chief Eng | Date | | | | |
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D Ø0 191 ---Ø0.38 5.00 -R0.50 4 PL 2.25 R0.10 2 PL 0.63+0.00 2 PL 0.813 С 2.56 REF С Ø0.194 1 6 R1.438 R1.75 0.63+0.00 D4021-9 BUSHING w lo and w 2.500 **D4021-7 HOOP** NOTES: 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B MP -9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 REF DART SPEC M304R DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA AJS 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT -7: 0.80 ibs
-9: 0.02 ibs DRAWN JPH CHECKED DRAWING NO. REV. B D4021 MFG. APPR. SHEET 3 OF 3 APPROVED TITLE MISC PARTS - 350 BASKET DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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| W/O: | | | WO | RK ORDER CHANG | SES | | | | |
| DATE | STEP | PRO | PROCEDURE CHANGE | | | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | | PAR #: | Fault Cated | orv: | NCR: Ye | s No DQ | A : | Date: | |
| | | | | | : N/C Closed: Da | | | | |
| NCR: | | | WORK ORDE | R NON-CONFORM | ANCE (NC | R) | | | |
| DATE | STEP | Description of NC Section A | Initial Chief Eng | Corrective Action Sec Action Description Chief Eng | tion B Sigr | اقة ∣ _{Sec} | cation tion C | Approval Chief Eng | Approval- QC Inspector |
| | | | Office Eng | Office Eng | | | <u> </u> | | |
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